<b>Work Order</b> Tuesday, September	ID 62362 28, 2010 11:53:14	AM										Page 1
Item ID: D3 Revision ID:	929-041			Accept					Setup	Start		
Item Name: Gus	sset Assembly									Stop		
Start Date: 9/2 Required Date: 10/ Reference:	8/2010 Start Qt 5/2010 Req'd Q	•			Cust Item II Customer:	D:						
Approvals: Pi	rocess Plan:	(	ate:10928	Tooling:		te:	-		Run	Start Stop		
Q	C:	Da	ate:	SPC (Y/N):	Da	te:						
Sequence ID/ Work Center ID	Operatio Descripti			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr											
D3929	Rev A		į,			•						
100 Waterjet		Memo		0.00				HS	(0-9	j - jc	(	
FLOW CNC Waterjet		1-Cut as per Dwg Dwg Rev:	D3929 — —								,	6
		2-Deburr if necess	ary									
	QC2- Inspe	ect parts off machine	e FAI/FAIB	0.00				ιR	10 -	9 - <b>à</b>	,9	
OC				0.00								

0.00

Memo

Quality Control

nge gory:	By  NCR: Yes	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Jory:	NCR: Yes				
gory:	NCR: Yes				
· ·		No DQA	<b>1</b> :	_ Date: _	
n:	QA: N/C C	Closed:		Date: _	
ER NON-CONFORMAN	ICE (NC	R)			
Corrective Action Section	В	Verific	ation		A
Action Description Chief Eng		& Section		Chief Eng	Approval QC Inspecto
	-  -  -				
E	ER NON-CONFORMAN  Corrective Action Section  Action Description	ER NON-CONFORMANCE (NC  Corrective Action Section B  Action Description Sign	Corrective Action Section B Action Description Sign & Section	Corrective Action Section B Action Description Sign & Verification Section C	Corrective Action Section B  Action Description Sign & Verification Section C Chief Eng

## Work Order ID 62362

Tuesday, September 28, 2010 11:53:14 AM



Page 2

Item ID:

D3929-041

Accept

Setup Start



**Revision ID:** 

Item Name:

Gusset Assembly

**Start Date:** 9/28/2010 **Required Date:** 10/5/2010

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

QC:

Date:\_\_\_\_\_

Date:\_\_\_\_\_

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 

0.00

0.00

0.00

0.00

**Tool ID** 

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

Large Fab

Large Fab

Memo

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 11585

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Quality Control

Memo

0.00

(6) PD 10.10.15

Dart	Aero	ospace	Ltd
------	------	--------	-----

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				- ÎNG.					
Part No	:	PAR #:			NCR: Yes	No DQ	<b>A</b> :	Date:	
	Re	solution:	Disposition	n:	_ QA: N/C Cld	sed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
<i>*</i>									
	1 1		1		,	1		1	1

## Work Order ID 62362

Tuesday, September 28, 2010 11:53:14 AM



Page 3

Item ID:

D3929-041

Accept

Setup Start



**Revision ID:** 

Item Name:

Required Date: 10/5/2010

Gusset Assembly

**Start Date:** 

9/28/2010

Start Qty: 6.00

Req'd Qty: 6.00

Memo



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

QC:

Process Plan:

Date:\_\_\_\_\_ Date:\_\_\_\_\_

Tooling:

SPC (Y/N):

Date:

Tool ID

Start

Stop

Stop



Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

0.00

0.00

Date:

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Insp. Number Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location: (1)

0.00

SAP10-10-15

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

mf 10-18

W/O:		WORK ORDER CHANGES					3
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category: N	CR: Ye	s No DQ	<b>4</b> :	Date: _	

Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annuoval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
		•				,					
		T- A									

NOTE: Date & initial all entries

Resolution:

## **Picklist Print**

Tuesday, September 28, 2010 11:53:19 AM

Work Order ID: 62362

Parent Item:

D3929-041

Parent Item Name: Gusset Assembly



60720

**Start Date:** 9/28/2010

Required Date: 10/5/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

### Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	63.9423	0.45	2.842105 B	16-9-3	) 9	
				<u>Location</u> MAT	114799	<b>Loc 6</b> 63.9 63.9	9423	Loc Code	<u>_1</u>	114799		<u>(</u>	
D3907-1  Bushing		Manufactured	No			130	Each	5.0000	2	12	Es.	10.10	0.15
				<u>Location</u> WA		Loc (	Oty 5	Loc Code			•		٠

362149 × 12

# **Dart Aerospace Ltd**

	-								,
W/O:			W	ORK ORDER CHANG	iES				•
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		A-3,1	<del></del>						
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Dispositio	n:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	₹)			
DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	& Secti		Chief Eng	QC Inspector
					ŀ				
							·		
		ì'							
	1 '								

DART AEROSPACE LTD	Work Order:	42362
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype
---	---------------	-----------

Drawing		Actual			Method of		<del></del>
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Com	ments
Ø0.375	+0.006/-0.00	01 ,377	Ы		U 1302		
0.500	+/-0.010	500	*		V		
0.500	+/-0.010	(500)	X		V		
4.036	+/-0.010	4.036	¥		V		
4.382	+/-0.010	4.382	×		V		
8.274	+/-0.010	8.274	<b>)</b> Ł		ν		
10.915	+/-0.010	10,911	Xer		V PRO 1B02		
1.000	+/-0.010	1,010	8		V		
11.198	+/-0.010	(1, 198	8		V		
0.500	+/-0.010	,500	X		V		
1.572	+/-0.010	1,572	y		V		
0.125	+/-0.010	121	y		V		
Measured by:	1B	Audited by:		2	Prototype Ap	proval:	N/A
Date:	1129-29	Date:	1005	21)		Date:	N/A

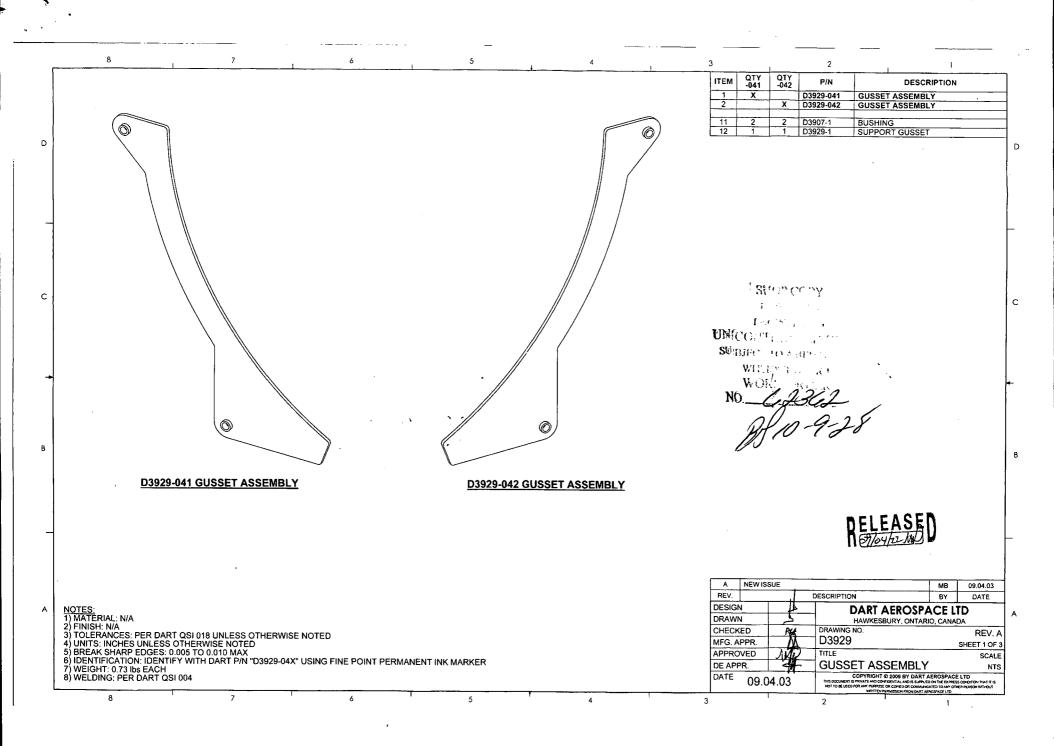
Measured by: \B	Audited by:	Prototype Approval: N/A
Date: 10-9-39	Date: /1009-30	Date: N/A

Re	v Date	Change		Revised by	Approved
Α	09.05.27	New Issue	P/O D3929-041/-042	KJ ox	
				• ()	<del></del>

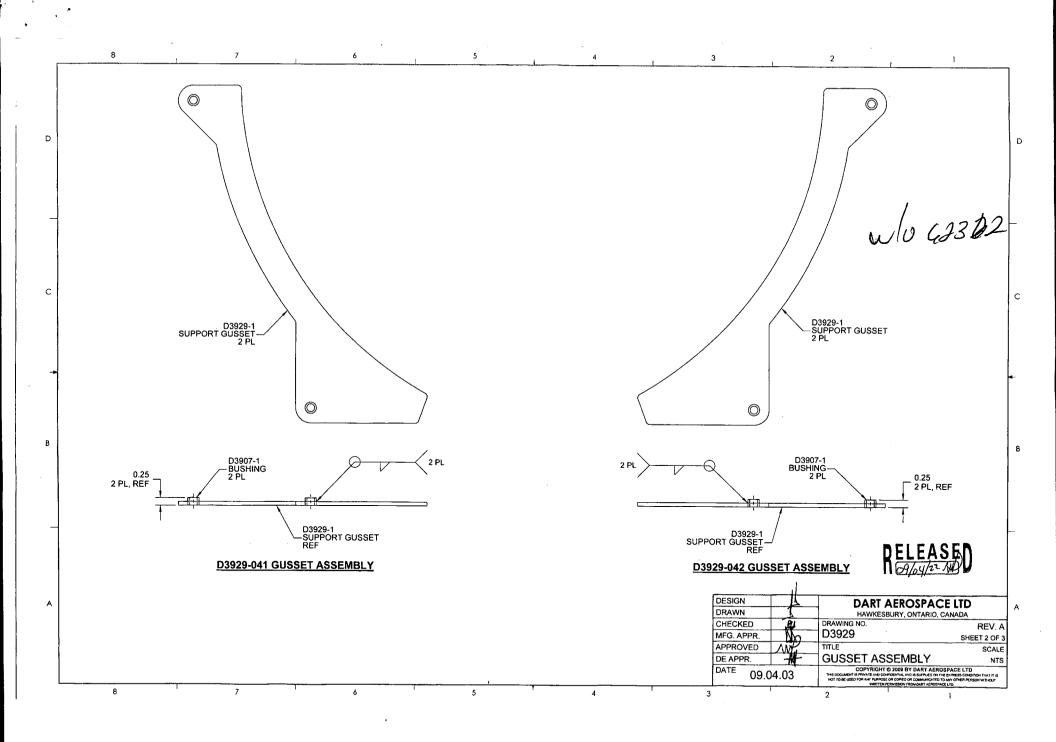
## **Dart Aerospace Ltd**

W/O:			WC	RK ORDER CHANC	GES	* .						
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					:							
Part No:		PAR #:	Fault Category: NCR: Yes No DC						)QA: Date:			
Resolution:			Disposition: Q			_ QA: N/C Closed:						
NCR:			WORK ORDE	R NON-CONFORM	ANCE (	NCR)						
DATE	STEP	Description of NC						ation	Approval	Approval		
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	9	ign & Date	Secti	on C	Chief Eng	QC Inspector		
								•				
					·			,				
					-							
							,					
	1 1		1 1		1		I .		ı	1		

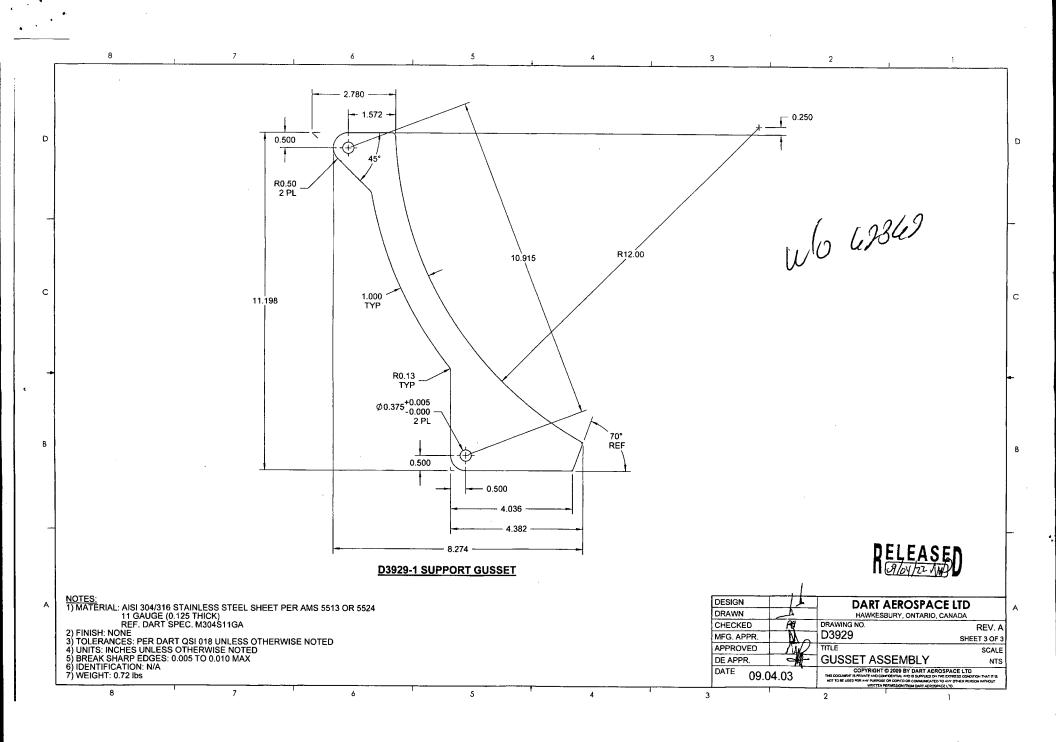
NOTE: Date & initial all entries



Dart Ae	rospace	e Ltd								r
W/O:			V	ORK ORDER CHAN	GES	_				
DATE	STEP	TEP PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:		PAR #:	Fault Category:			l: Yes	lo DQA:		_ Date: _	
	R	esolution:	Disposition:			QA: N/C Closed: D				
NCR:			WORK OR	DER NON-CONFORM	<b>JANCE</b>	(NCR	)			
DATE	STEP	Description of NC Section A				ction B Sign &		cation	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng Chief Eng			Date		ion C	Chief Eng	QC inspector
			***************************************							



Dart Ae	rospace	Ltd							۲,
W/O:			WO	RK ORDER CHANGE	S				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			ı						
<del></del>									
Part No:		PAR #:	Fault Categ	NCR: Yes	No DC	)A:			
Resolution:			Disposition	QA: N/C	Closed: _	Date:			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	<b>R</b> ).			
DATE		Description of NC	Corrective Action Section			Verif	ication	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign Date	Section C		Chief Eng	QC Inspector
					ŀ				
		- 11.				-			



Dart Ae	rospace	e Ltd								r		
W/O:			WO	RK ORDER CHAN	GES			-		•		
DATE STEP PR			CEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
l.,												
					3							
	<u> </u>		A 1		}							
Part No: PAR #:		PAR #:	Fault Category:			NCR: Yes No DQA: Date:						
	R	esolution:	Disposition:			_ QA: N/C Closed:						
NCR:		V	VORK ORDE	ER NON-CONFORM	<b>JANCE</b>	(NCR)						
DATE	STEP	Description of NC			ection B			cation	Approval	Approval		
DAIL		- SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date		Section C	Chief Eng	QC Inspector	
		•										
									:	<u> </u>		
					ļ			ý.				